

Dec's

Work Order ID 75487

75487

Page 1

October-24-11 10:23:19 AM

Item ID: D3805-041 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Wearplate Assembly Fwd, Low Gear Stop *NS2*

Start Date: 24/10/2011 Start Qty: 8.00 *8* Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 8.00 *8* Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/10/24 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3805	B

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1-weld D3806-1 to D3805-1 together as per dwg D3805

304 S.S. Welding Rod

BATCH #: M118367

2-Transfer drill holes in bar

X/0 11-12-14 JBL

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

QC 11-12-14

10X Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(40)			
130 *130* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 3:15 OVEN TEMPERATURE: 320 JF FINISH TIME: 3:45	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

10x 10 M/L 11/12/14

10 11-12-14

M118484

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
Small Fab	Memo	0.00							
Small Fab	1- Bond D3807-1 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg BATCH: <u>M119597</u>								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>F21</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

Ac 11.12.17 x10

5 11/12/19

(410)

*x10 4/12/19
counted & measured*

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

R11/12/19
(10)

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October-24-11 10:23:24 AM

75487

D3805-041

Required Date: 07/11/2011

Required Qty: 8.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:EC IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

[illegible]

B 75677
B 76741

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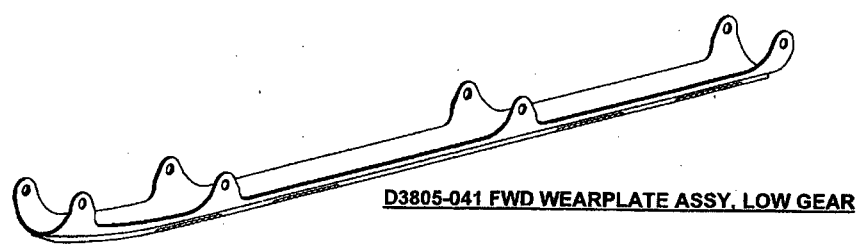
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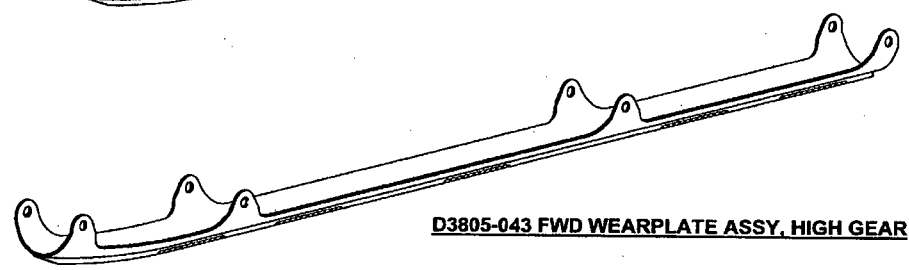
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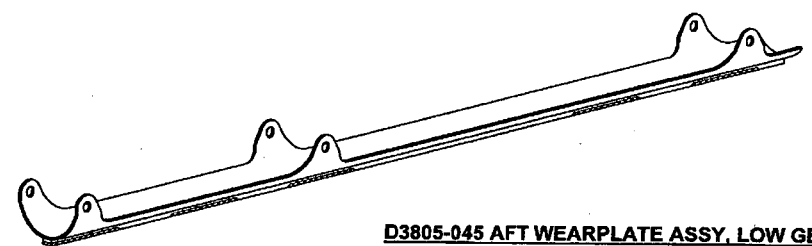
8 7 6 5 4 3 2 1



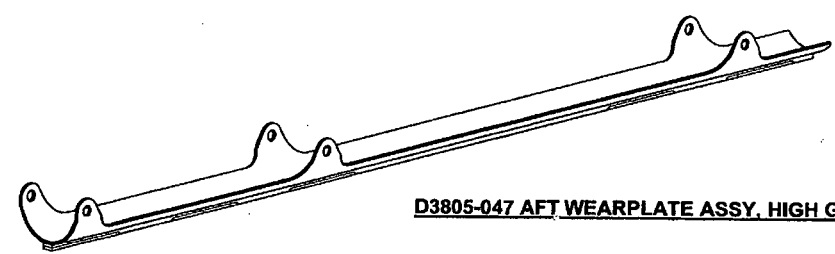
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75487 M.C.U
11/10/24

RELEASED
2011-10-03
MB

B	REVISED D3805-1F1-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3805	SHEET 1 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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Dart Aerospace Ltd

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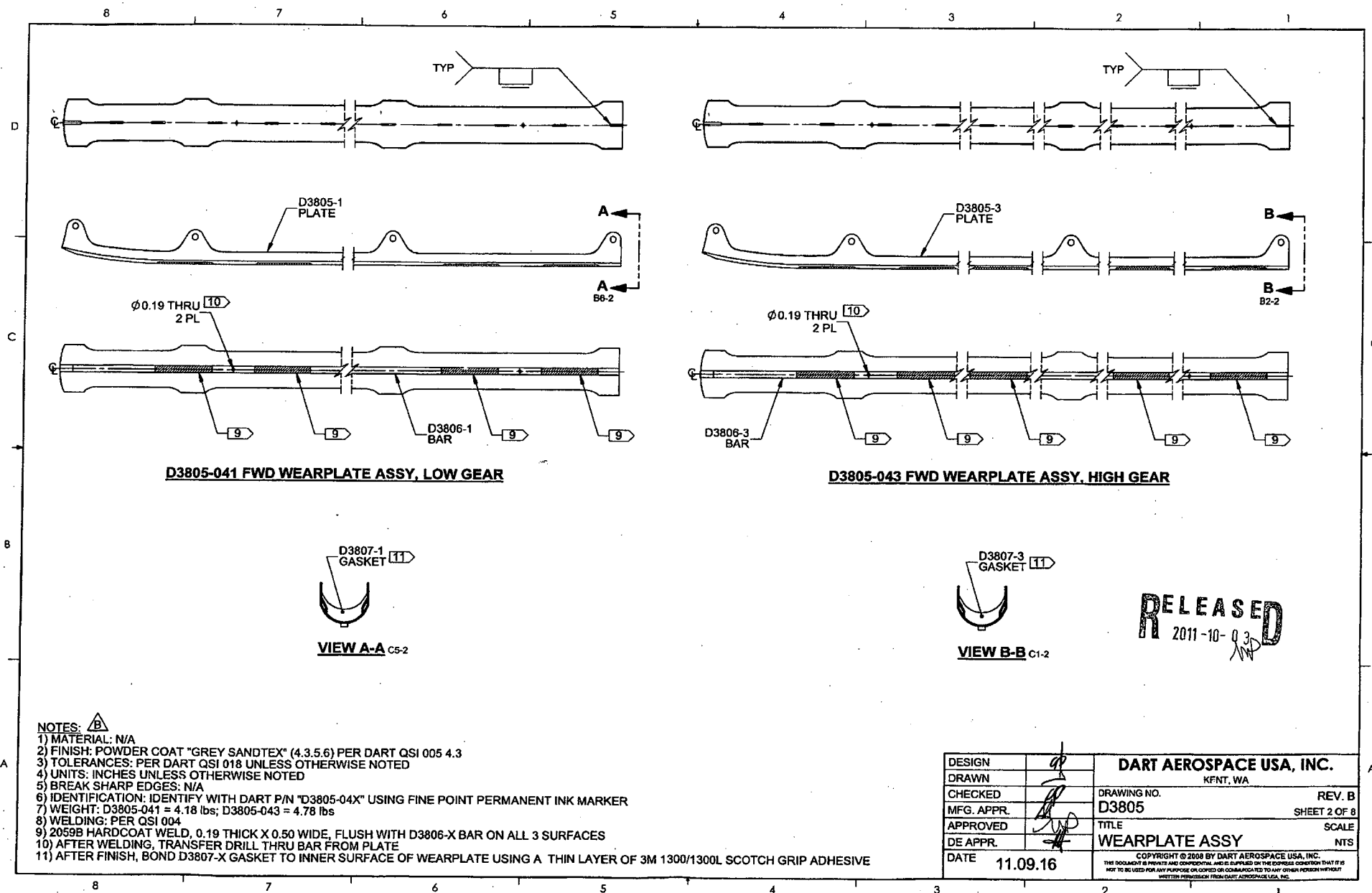
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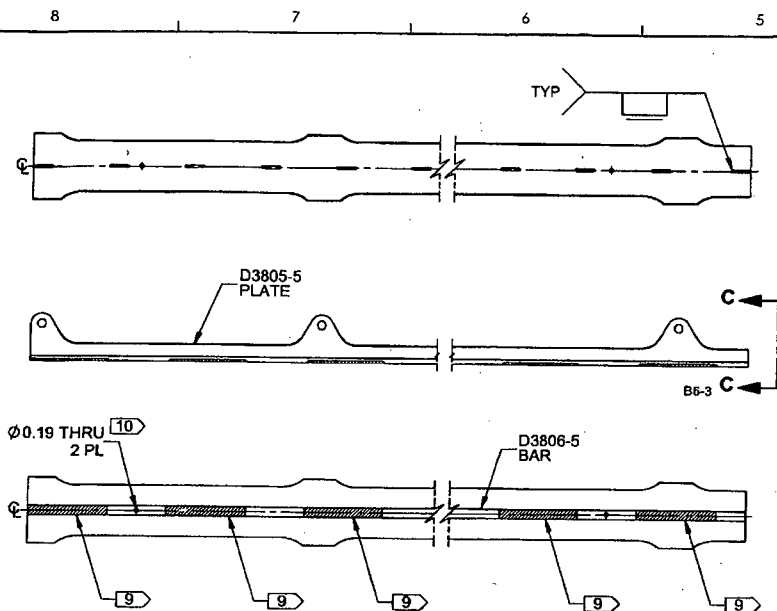
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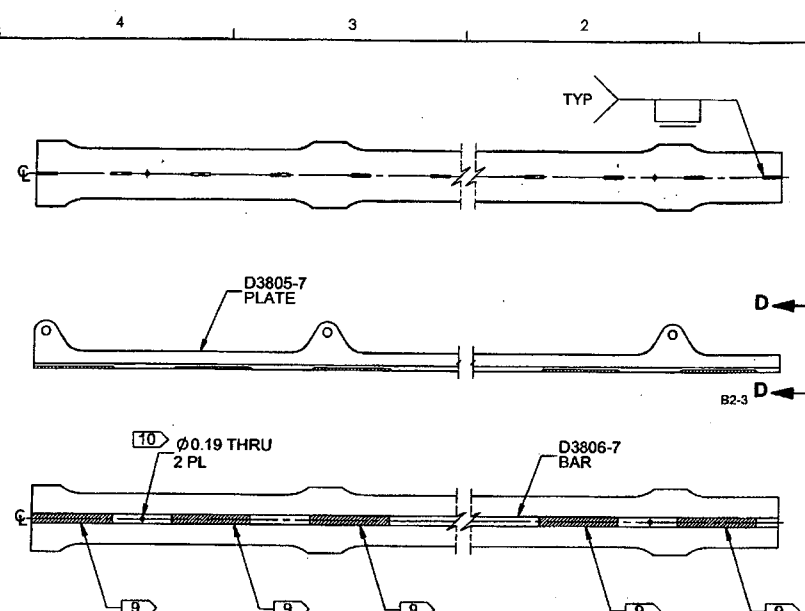
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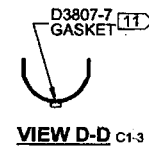
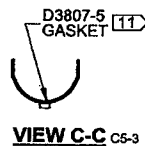
75487



D3805-045 AFT WEARPLATE ASSY.



D3805-047 AFT WEARPLATE ASSY.



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.		D3805	SHEET 3 OF 8
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RELEASED
2011-10-03
JMP

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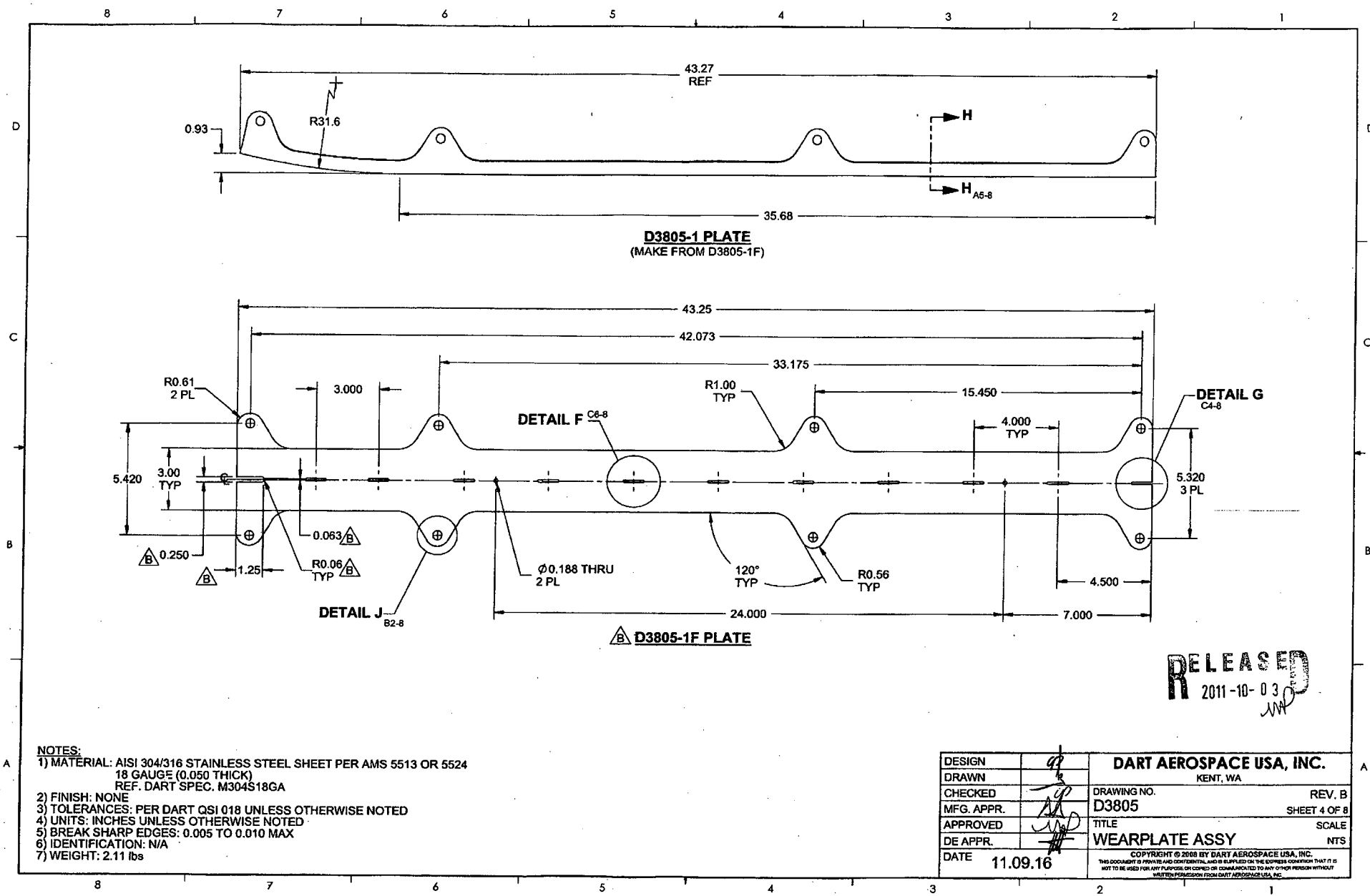
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- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.11 lbs

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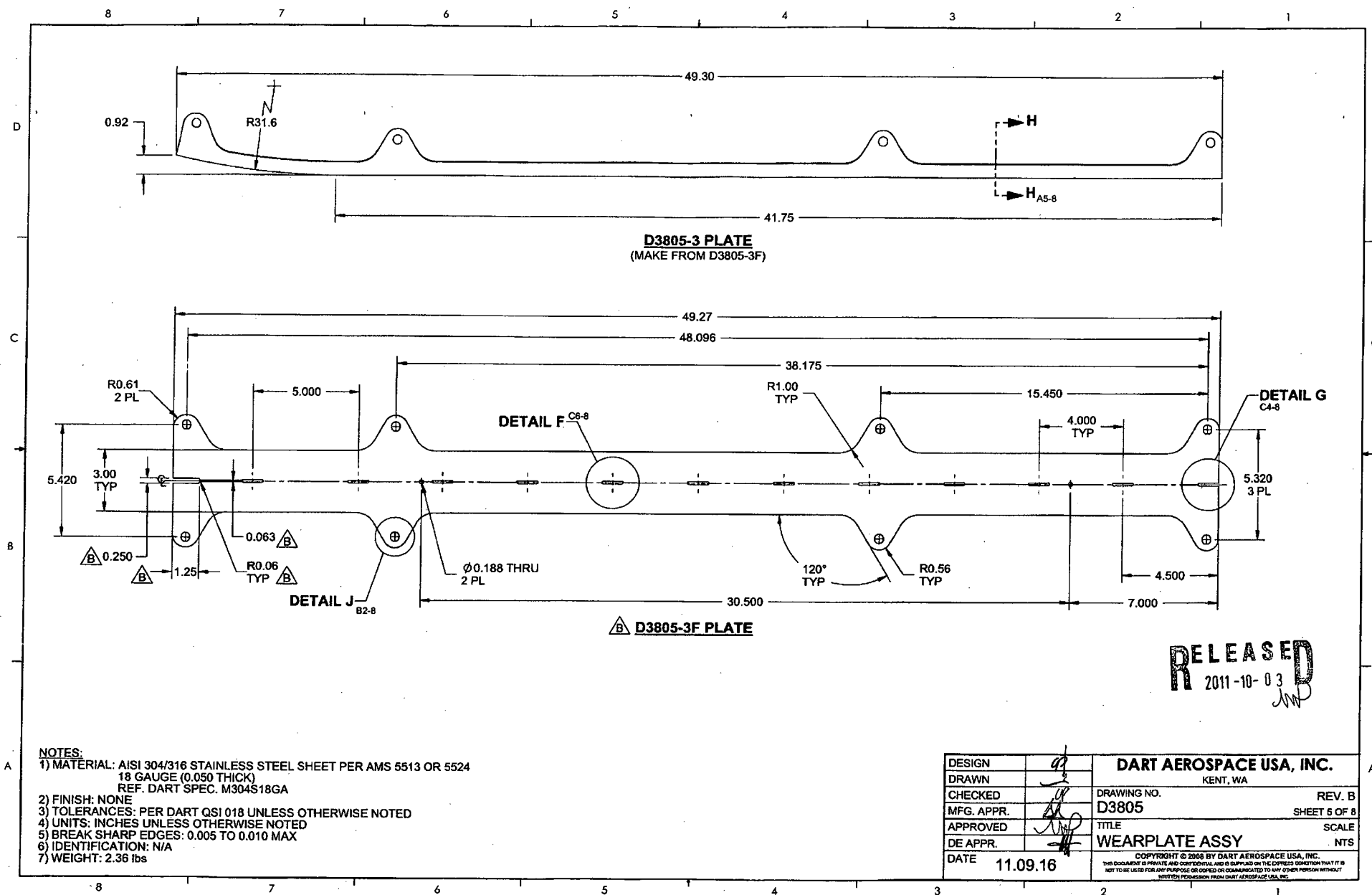
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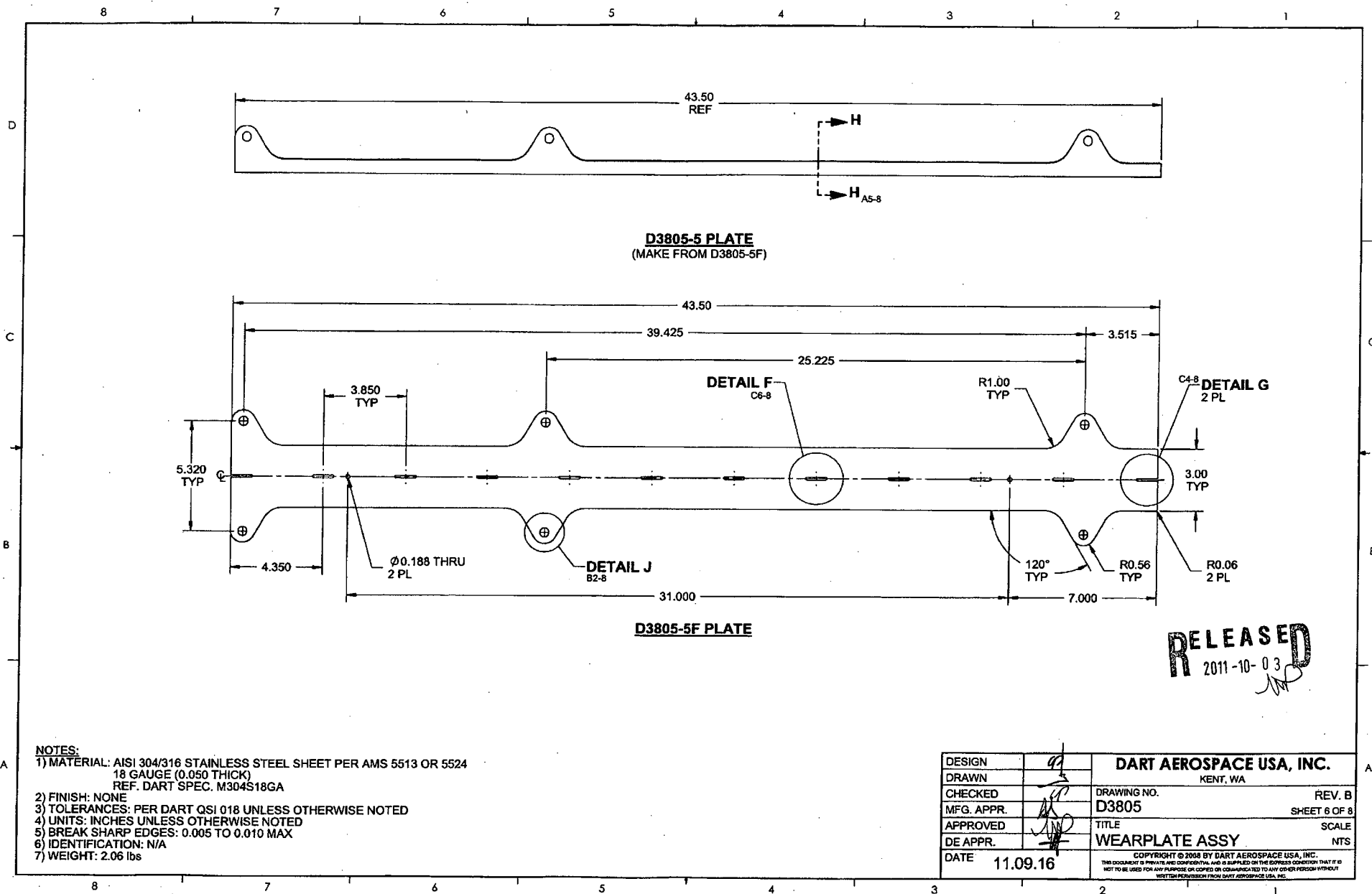
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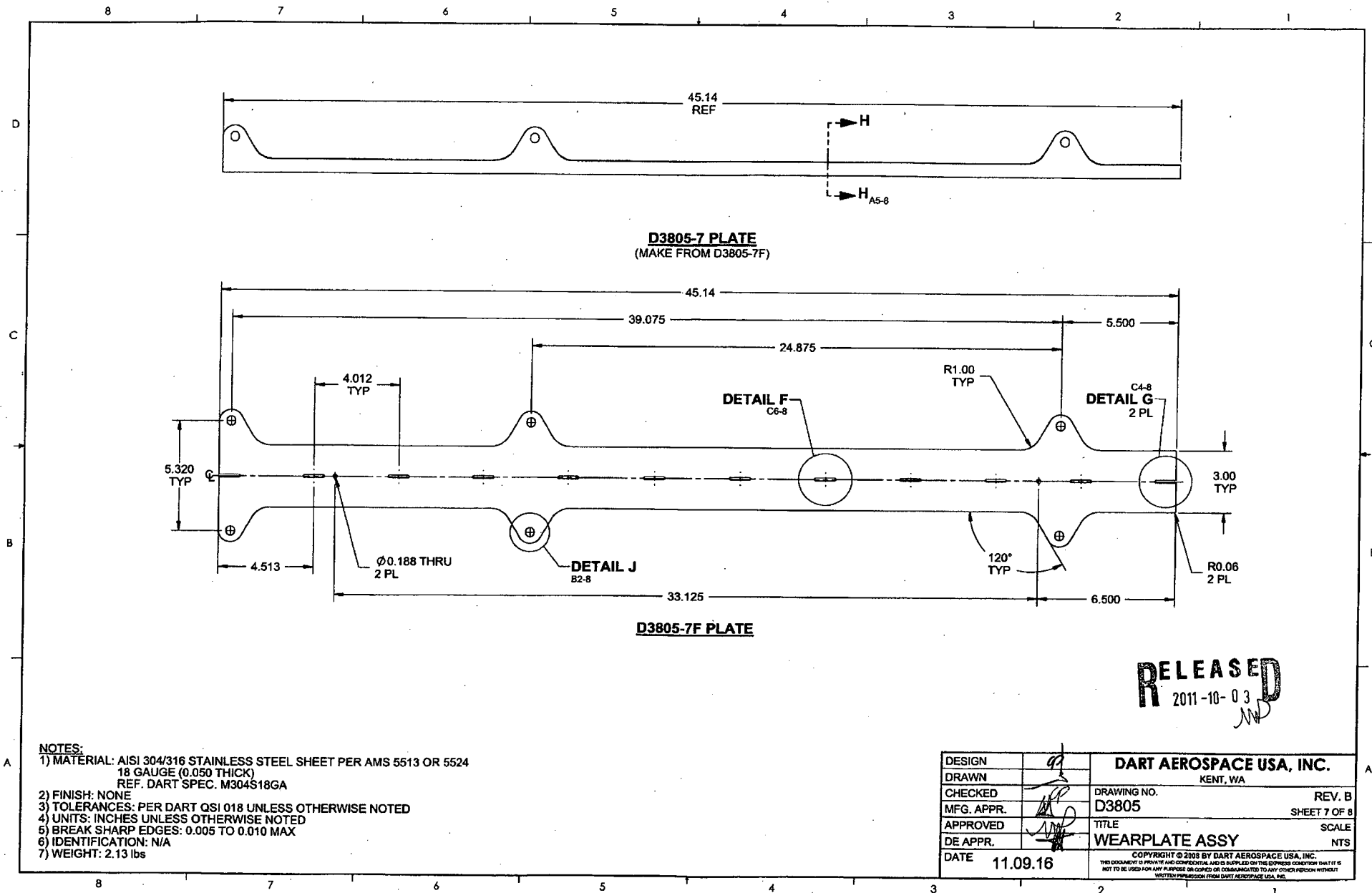
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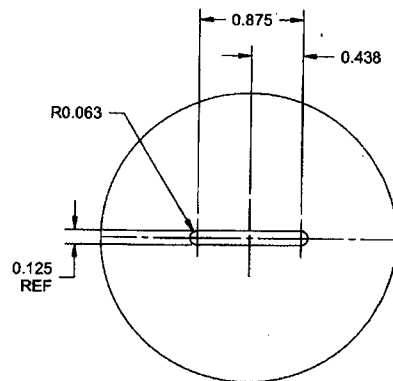
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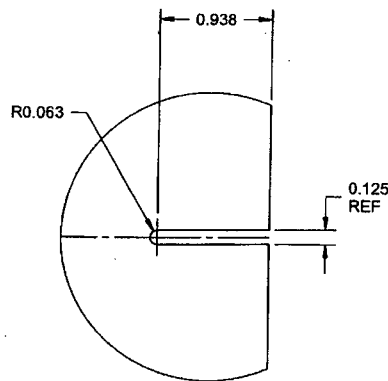
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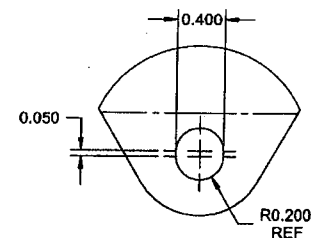
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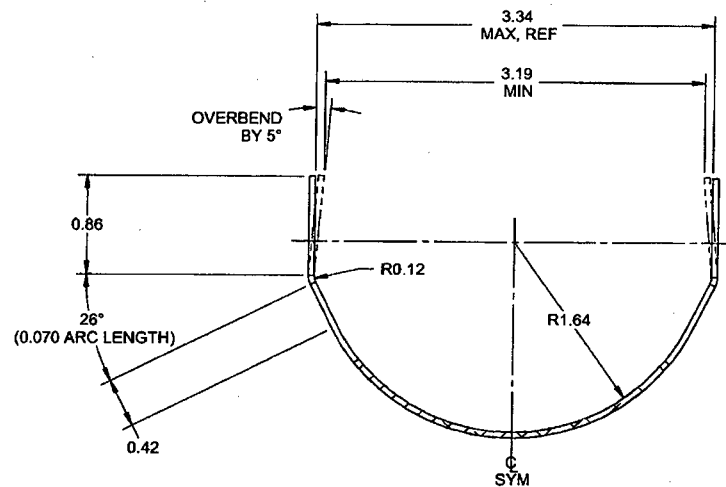
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

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2011-10-03
WV

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